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वस्त्रादि — हथकरघा निर्मित सूती दरियाँ —  
विशिष्टि

( तीसरा पुनरीक्षण )

**Textiles — Handloom Cotton  
Durries — Specification**

( Third Revision )

ICS 59.080.30

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## FOREWORD

This Indian Standard (Third Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Handloom and Khadi Sectional Committee had been approved by the Textiles Division Council.

This standard was originally published in 1959 and was subsequently revised in 1972 and 1991. The standard has again been revised to incorporate the following major changes:

- a) Method of test for count of yarn along with its tolerance has been specified;
- b) Tolerances for ends/dm, picks/dm and mass have been modified;
- c) Test method for identification of material has been incorporated;
- d) All amendments have been incorporated;
- e) Sampling plan has been updated;
- f) BIS certification marking clause has been modified; and
- g) References to Indian Standards have been updated.

The composition of the Committee responsible for the formulation of this standard is given in Annex D.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 2022 'Rules for rounding off numerical values (*second revision*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

*Indian Standard*

# TEXTILES — HANDLOOM COTTON DURRIES — SPECIFICATION

( Third Revision )

**1 SCOPE**

**1.1** This standard prescribes constructional particulars and other requirements for twenty four varieties of handloom cotton durries.

**1.2** This standard does not specify general appearance, feel, finish, etc of the cloth.

**2 REFERENCES**

The standards listed in Annex A contain provisions which, through reference in this text, constitute provisions of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent edition of these standards.

**3 ATMOSPHERIC CONDITIONS FOR TESTING**

Test specimens may be conditioned and tested in the prevailing atmosphere for determining the conformity of the durries to this standard. However, in all cases of disputes, specimen shall be conditioned and tested in the standard atmosphere as specified in the referred Indian Standards on test methods.

**4 MANUFACTURE****4.1 Yarn**

**4.1.1** The cotton yarn used in the manufacture of the durries shall conform to the requirements specified in IS 171.

**4.2** The durries shall be woven in plain weave. The number of ends included in each selvage shall be between 6 to 18.

**4.2.1** The warp threads at each end of durries shall be knotted together to form a fringe measuring 5 cm and to prevent fraying of weft threads. Alternatively, the transverse ends of durries shall be spliced.

**5 REQUIREMENTS**

**5.1** The durries shall conform the requirements specified in Table 1.

**5.1.1** However, breaking load requirement shall be an optional requirement. It shall be enforced only when conformance of cotton yarn to the requirements specified in IS 171 is not known.

**5.2** The durries shall also conform to the requirements specified in Table 2.

**5.3 Dimensions**

Length and width of the durries when determined in accordance with IS 1954 shall be as agreed to between the buyer and the seller or as declared by the seller subject to the tolerances of  $\pm 3$  cm on length and on width.

**5.4** In order to illustrate or specify the indeterminable characteristics, such as general appearance, feel and shade of the durries, a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

**5.4.1** The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

**6 INSPECTION**

**6.1** The durries when visually inspected should be free from the major flaws listed in Annex B.

**6.1.1** The number of permissible flaws per durry shall be as agreed to between the buyer and the seller.

**7 MARKING**

**7.1** The product shall be suitably marked with the following information:

- a) Name of the material;
- b) Length (m) and width (cm);
- c) Variety and GSM (g/m<sup>2</sup>);
- d) Indication of the source of manufacture; and
- e) Other declarations required as per law in force.

**7.2 BIS Certification Marking**

The product conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder, and the product may be marked with the Standard Mark.

**8 PACKING**

The durries shall be packed as per the requirements of the buyer.

**Table 1 Constructional Particulars and Breaking Load Requirements for Handloom Cotton Durries**

(Clause 5.1)

| Sl No. | Variety No. | Count of Yarn: Universal Count (English Count, Ne) |                       | Ends/dm | Pick/dm                      | Mass<br>g/m <sup>2</sup> | Breaking Load on<br>5 cm × 20 cm Strips |          |
|--------|-------------|----------------------------------------------------|-----------------------|---------|------------------------------|--------------------------|-----------------------------------------|----------|
|        |             | Warp                                               | Weft                  |         |                              |                          | Warp way                                | Weft way |
| (1)    | (2)         | (3)                                                | (4)                   | (5)     | (6)                          | (7)                      | (8)                                     | (9)      |
| i)     | 1           | 60 tex × 3<br>(10s/3)                              | 394 tex<br>(1.5s)     | 65      | 140                          | 750                      | 900                                     | 550      |
| ii)    | 2           | 60 tex × 3<br>(10s/3)                              | 295 tex<br>(2s)       | 65      | 220                          | 815                      | 900                                     | 1 800    |
| iii)   | 3           | 60 tex × 3<br>(10s/3)                              | 295 tex<br>(2s)       | 40      | 110 (double)                 | 850                      | 600                                     | 1 800    |
| iv)    | 4           | 60 tex × 3<br>(10s/3)                              | 60 tex × 3<br>(10s/3) | 65      | 315                          | 750                      | 900                                     | 475      |
| v)     | 5           | 60 tex × 3<br>(10s/3)                              | 98 tex<br>(6s)        | 40      | 110 (6-strand<br>untwisted)  | 850                      | 600                                     | 2 600    |
| vi)    | 6           | 60 tex × 2<br>(10s/2)                              | 295 tex<br>(2s)       | 40      | 80 (double)                  | 650                      | 400                                     | 1 300    |
| vii)   | 7           | 60 tex × 2<br>(10s/2)                              | 295 tex<br>(2s)       | 40      | 95 (double)                  | 715                      | 400                                     | 1 600    |
| viii)  | 8           | 60 tex × 2<br>(10s/2)                              | 295 tex<br>(2s)       | 55      | 200                          | 750                      | 550                                     | 1 800    |
| ix)    | 9           | 60 tex × 2<br>(10s/2)                              | 98 tex × 2<br>(6s/2)  | 55      | 280                          | 715                      | 550                                     | 2 800    |
| x)     | 10          | 60 tex × 2<br>(10s/2)                              | 98 tex<br>(6s)        | 40      | 184<br>(3-strands)           | 640                      | 400                                     | 2 000    |
| xi)    | 11          | 60 tex × 2<br>(10s/2)                              | 60 tex<br>(10s)       | 72      | 272<br>(double)              | 460                      | 650                                     | 2 000    |
| xii)   | 12          | 60 tex × 4<br>(10s/4)                              | 295 tex<br>(2s)       | 40      | 80<br>(double)               | 715                      | 800                                     | 1 300    |
| xiii)  | 13          | 60 tex × 5<br>(10s/5)                              | 295 tex<br>(2s)       | 40      | 208                          | 760                      | 100                                     | 1 700    |
| xiv)   | 14          | 60 tex × 6<br>(10s/6)                              | 98 tex<br>(6s)        | 35      | 80 (8- strands<br>untwisted) | 880                      | 1 100                                   | 700      |
| xv)    | 15          | 30 tex × 2<br>(20s/2)                              | 295 tex<br>(2s)       | 43      | 150                          | 600                      | 300                                     | 1 200    |
| xvi)   | 16          | 30 tex × 2<br>(20s/2)                              | 295 tex<br>(2s)       | 50      | 144                          | 500                      | 350                                     | 1 100    |

Table 1 (Concluded)

| Sl No.                    | Variety No. | Count of Yarn: Universal Count (English Count, Ne) |                       | Ends/dm | Pick/dm      | Mass<br>g/m <sup>2</sup> | Breaking Load on<br>5 cm × 20 cm Strips<br>N           |          |
|---------------------------|-------------|----------------------------------------------------|-----------------------|---------|--------------|--------------------------|--------------------------------------------------------|----------|
|                           |             | Warp                                               | Weft                  |         |              |                          | Warp way                                               | Weft way |
| (1)                       | (2)         | (3)                                                | (4)                   | (5)     | (6)          | (7)                      | (8)                                                    | (9)      |
| xvii)                     | 17          | 30 tex × 2<br>(20s/2)                              | 295 tex<br>(2s)       | 50      | 216          | 725                      | 350                                                    | 1 800    |
| xviii)                    | 18          | 30 tex × 2<br>(20s/2)                              | 295 tex<br>(2s)       | 65      | 160          | 575                      | 450                                                    | 2 450    |
| xix)                      | 19          | 30 tex × 2<br>(20s/2)                              | 148 tex<br>(4s)       | 64      | 208          | 380                      | 450                                                    | 1 000    |
| xx)                       | 20          | 30 tex × 2<br>(20s/2)                              | 60 tex<br>(10s)       | 70      | 300 (double) | 450                      | 500                                                    | 2 300    |
| xxi)                      | 21          | 30 tex × 3<br>( 20s/2 )                            | 295 tex<br>( 2s )     | 48      | 168          | 600                      | 500                                                    | 1 300    |
| xxii)                     | 22          | 98 tex × 2<br>(6s/2)                               | 148 tex × 2<br>(4s/2) | 40      | 200          | 695                      | 500                                                    | 1 600    |
| xxiii)                    | 23          | 148 tex × 2<br>(4s/2)                              | 148 tex × 2<br>(4s/2) | 32      | 232          | 830                      | 350                                                    | 1 800    |
| xxiv)                     | 24          | 148 tex × 2<br>(4s/2)                              | 148 tex × 2<br>(4s/2) | 42      | 168          | 630                      | 450                                                    | 1 300    |
| Tolerance,<br>percent     | —           | ± 5                                                | ± 5                   | ± 5     | ± 5          | ± 5                      | - 5 on average value and<br>- 15 on individual reading |          |
| Method of<br>Test, Ref to | —           | IS 3442                                            |                       | IS 1963 |              | IS 1964 or<br>Annex C    | IS 1969 (Part 1)                                       |          |

Table 2 Colour Fastness Requirements for Handloom Cotton Durries

(Clause 5.2)

| Sl No. | Characteristic        | Requirement        | Method of Test, Ref to              |
|--------|-----------------------|--------------------|-------------------------------------|
| (1)    | (2)                   | (3)                | (4)                                 |
| i)     | Colour fastness:      |                    |                                     |
|        | a) Light              | 4 or better        | IS/ISO 105-B01 or<br>IS/ISO 105-B02 |
|        | b) Washing Test A(1): |                    | IS/ISO 105-C10                      |
|        | 1) Change in colour   | 3 or better        |                                     |
|        | 2) Staining on fabric | 3 or better        |                                     |
|        | c) Rubbing            | 4 or better        | IS/ISO 105-X12                      |
| ii)    | Fibre identification  | 100 percent cotton | IS 667                              |

**9 SAMPLING****9.1 Lot**

The quantity of the durries of the same variety delivered to one buyer against one despatch note shall constitute a lot.

**9.2** The conformity of the lot to the various requirements specified in the standard shall be

determined on the basis of tests carried out on the samples selected from the lot.

**9.3** Unless otherwise agreed, the number of durries selected at random for inspection shall be in accordance with Table 3.

**9.3.1** For selection of samples at random from the lot, procedure given in IS 4905 may be followed.

**Table 3 Sample Size and Permissible Number of Non-conforming Durries**

(Clause 9.3)

| Sl No. | Lot Size          | Sample Size | Permissible Number of Non-conforming Items | Sub-sample Size |
|--------|-------------------|-------------|--------------------------------------------|-----------------|
| (1)    | (2)               | (3)         | (4)                                        | (5)             |
| i)     | Up to 90          | 5           | 0                                          | 3               |
| ii)    | 91 to 150         | 8           | 0                                          | 3               |
| iii)   | 151 to 500        | 13          | 1                                          | 5               |
| iv)    | 501 to 1 200      | 20          | 1                                          | 5               |
| v)     | 1 201 to 10 000   | 32          | 2                                          | 8               |
| vi)    | 10 001 to 35 000  | 50          | 3                                          | 8               |
| vii)   | 35 001 to 500 000 | 80          | 5                                          | 13              |
| viii)  | 500 001 and above | 125         | 7                                          | 13              |

**9.4 Number of Samples and Criteria for Conformity**

It shall be as follows:

| Sl No. | Characteristics                                             | Number of Samples               | Criterion for Conformity                                                                               |
|--------|-------------------------------------------------------------|---------------------------------|--------------------------------------------------------------------------------------------------------|
| (1)    | (2)                                                         | (3)                             | (4)                                                                                                    |
| i)     | Count, ends, picks, mass length width and visual inspection | According to col (3) of Table 3 | Number of non-conforming durries shall not exceed the corresponding number given in col (4) of Table 3 |
| ii)    | Colour fastness, fibre identification and breaking load     | According to col (5) of Table 3 | All the durries under test shall meet the requirement                                                  |

## ANNEX A

(Clause 2)

## LIST OF REFERRED STANDARDS

| <i>IS No.</i>              | <i>Title</i>                                                                                                                                                      | <i>IS No.</i>                          | <i>Title</i>                                                                                                           |
|----------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------|------------------------------------------------------------------------------------------------------------------------|
| IS 171 : 1993              | Textiles — Ring spun grey cotton yarn for weaving — specification ( <i>fourth revision</i> )                                                                      | IS 3442 : 2023                         | Textiles — Method for determination of crimp and linear density of yarn removed from fabric ( <i>second revision</i> ) |
| IS 667 : 1981              | Methods for identification of textile fibres ( <i>first revision</i> )                                                                                            | IS 4905 : 2015/<br>ISO 24153 :<br>2009 | Random sampling and randomization procedures ( <i>first revision</i> )                                                 |
| IS 1954 : 1990             | Determination of length and width of woven fabrics — Methods ( <i>second revision</i> )                                                                           | IS/ISO 105-B01 :<br>2014               | Textiles — Tests for colour fastness: Part B01 Colour fastness to light: Daylight                                      |
| IS 1963 : 1981             | Methods for determination of threads per unit length in woven fabrics ( <i>second revision</i> )                                                                  | IS/ISO 105-B02 :<br>2014               | Textiles — Tests for colour fastness: Part B02 Colour fastness to artificial light: Xenon arc fading lamp test         |
| IS 1964 : 2001             | Textiles — Methods for determination of mass per unit length and mass per unit area of fabrics ( <i>second revision</i> )                                         | IS/ISO 105-C10 :<br>2006               | Textiles — Tests for colour fastness: Part C10 Colour fastness to washing with soap or soap and soda                   |
| IS 1969 (Part 1) :<br>2018 | Textiles — Tensile properties of fabrics: Part 1 Determination of maximum force and elongation at maximum force using the strip method ( <i>fourth revision</i> ) | IS/ISO 105-X12 :<br>2016               | Textiles — Tests for colour fastness: Part X12 Colour fastness to rubbing ( <i>first revision</i> )                    |

## ANNEX B

(Clause 6.1)

### LIST OF MAJOR FLAWS

- |                                                                                                                                                                                                                   |                                                                                                                                                                           |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| a) One or more ends missing in the body of the material throughout its length, more than three ends missing at a place and running over 60 cm, or prominently noticeable double end running throughout the piece; | k) More than two adjacent ends running parallel broken or missing and extending beyond 10 cm;                                                                             |
| b) Undressed snarls noticeable over a length exceeding 5 percent of the length of the piece;                                                                                                                      | m) Noticeable warp or weft float in the body of the fabric;                                                                                                               |
| c) Smash definitely rupturing the texture of the fabric;                                                                                                                                                          | n) Noticeable oil or other stain in the fabric;                                                                                                                           |
| d) Hole, cut or tear;                                                                                                                                                                                             | p) Oily weft in the fabric;                                                                                                                                               |
| e) Reed marks prominently noticeable over a length exceeding 5 percent of the piece;                                                                                                                              | q) Prominently noticeable slub;                                                                                                                                           |
| f) Defective or damaged selvedge noticeable over a length exceeding 5 percent of the length of the piece;                                                                                                         | r) Conspicuous broken pattern;                                                                                                                                            |
| g) Skewing of more than three percent on weft;                                                                                                                                                                    | s) Gout due to foreign matter, usually lint or waste woven into the fabric;                                                                                               |
| h) Weft crack or two or more missing picks across the width of the fabric;                                                                                                                                        | t) Prominent selvedge defect;                                                                                                                                             |
| j) Warp or weft bar due to the difference in raw material, count, twist, lustre, colour, shade or spacing of adjacent groups of yarns (starting mark);                                                            | u) Significant shading or listing in fabrics having a gradual change in tone or depth of shade of fabric (excluding selvedge or border running parallel to the selvedge); |
|                                                                                                                                                                                                                   | v) Coloured flecks;                                                                                                                                                       |
|                                                                                                                                                                                                                   | w) Blurred or dark patch;                                                                                                                                                 |
|                                                                                                                                                                                                                   | y) Patchy, streaky or uneven dyeing;                                                                                                                                      |
|                                                                                                                                                                                                                   | z) Dye bar; and                                                                                                                                                           |
|                                                                                                                                                                                                                   | aa) Fuzzy appearance.                                                                                                                                                     |

## ANNEX C

(Table 1)

### METHOD FOR DETERMINATION OF MASS OF FABRIC

**C-1** Cut four specimens of 100 mm × 100 mm each from a sample. Condition all the specimen a desiccator charged with saturated solution of sodium nitrate at 27 °C ± 2 °C for a period of 24 hours. Remove all the specimens from the desiccator and

immediately determine their collective mass in a weighing balance to the nearest milligram.

**C-2** Calculate the mass of durries in g/m<sup>2</sup>.

**ANNEX D***(Foreword)***COMMITTEE COMPOSITION**

Handloom and Khadi Sectional Committee, TXD 08

| <i>Organization</i>                                                | <i>Representative(s)</i>                                                              |
|--------------------------------------------------------------------|---------------------------------------------------------------------------------------|
| Weavers Service Centre, Delhi                                      | SHRI VISHESH NAUTIYAL ( <b>Chairperson</b> )<br>SHRI VIKAS KUMAR ( <i>Alternate</i> ) |
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| Central Pollution Control Board, New Delhi                         | SHRI P. K. MISHRA<br>SHRI RISHABH SRIVASTAV ( <i>Alternate</i> )                      |
| Central Reserve Police Force, New Delhi                            | SHRI D. P. UPADHYAY<br>SHRI SANJEEV KUMAR SINGH ( <i>Alternate</i> )                  |
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| Gandhigram Rural Institute, Dindigul                               | REPRESENTATIVE                                                                        |
| Haryana Khadi Gramodyog Sangh, Karnal                              | SHRI PAWAN GARG<br>SHRI R. S. YADAV ( <i>Alternate</i> )                              |
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| Indian Institute of Handloom Technology, Varanasi                  | DR P. THENNARASU                                                                      |
| Indian Institute of Handloom Technology, Jodhpur                   | DR J. SIVAGNANAM                                                                      |
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| Madhya Bharat Khadi Sangh, Gwalior                                 | SHRIMATI NEELU MEKLE<br>SHRI HARISH MEKLE ( <i>Alternate</i> )                        |
| Mahatma Gandhi Institute for Rural Industrialization, Wardha       | REPRESENTATIVE                                                                        |

| <i>Organization</i>                                               | <i>Representative(s)</i>                                                                                           |
|-------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------|
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*Member Secretary*  
SHRI SWAPNIL  
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(TEXTILES), BIS



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|           |               |               |

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